



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2803-041

Job Sheet 172088



Part No: D2803-041

Job Qty: 5 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP REV:G 16.06.23 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	2/17/18	2/17/18	0.00	0.00	Start Up Small Fab-1		
100	Small Fab	5 pcs	2/17/18	2/17/18	0.00	0.37	Small Fab-2		
110	QC	5 pcs	2/17/18	2/17/18	0.00	0.00	QC5		
120	Powdercoat	5 pcs	2/17/18	2/17/18	0.00	0.22	Powdercoat1		
130	QC	5 pcs	2/17/18	2/17/18	0.00	0.00	QC3		
150	Small Fab	5 pcs	2/19/18	2/19/18	0.00	0.37	Small Fab-2		
160	QC	5 pcs	2/19/18	2/19/18	0.00	0.00	QC5		
170	Packaging	5 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3-1		
180	QC21-SA	5 Ea	2/19/18	2/19/18	0.00	0.00	QC21		

Part Op 100 - Press D2805-1 and D2809 into arm as per Dwg D2803

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - White Gloss (Ref:4.3.5.1) per QSI005 4.3 Alum START TIME: 3:25 OVEN TEMPERATURE: 300°

FINISH TIME: 3:55

130 - QC3- Inspect Part Finish

150 - Assemble as per Dwg D2803.

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2803-1	Bracket	5 Ea (1 ea)	90-Start up Operation	F146599
D2805-1	Stop	5 Ea (1 ea)	90-Start up Operation	F149353 2x F163359 3x
D2809	Washer	5 Ea (1 ea)	90-Start up Operation	F138757
AN3C16A	Bolt	10 Ea (2 ea)	150-Small Fab	F138757
D3672-15	Phenolic Washer	20 Ea (4 ea)	150-Small Fab	F138757
MS21043-3	Nut	10 Ea (2 ea)	150-Small Fab	F138757

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2803-1	5	6	0
	D2805-1	5	12	0
	D2809	5	27	0
	AN3C16A	10	40	0
150-Small Fab	D3672-15	20	3	0
	MS21043-3	10	1,206	0

601302

Plex 2/12/18 1:49 PM Dart.Gagnon.Michelle

Part Specifications

Specifications could not be found.

Plex 2/12/18 1:49 PM Dart.Gagnon.Michelle

**Container No: S044581****Part: D2803 – 041****Job No: 172088****Serial No/Batch: S044581****Revision: D2803****Inspector:**

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/22/18

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SUBJECT TO AMENDMENT

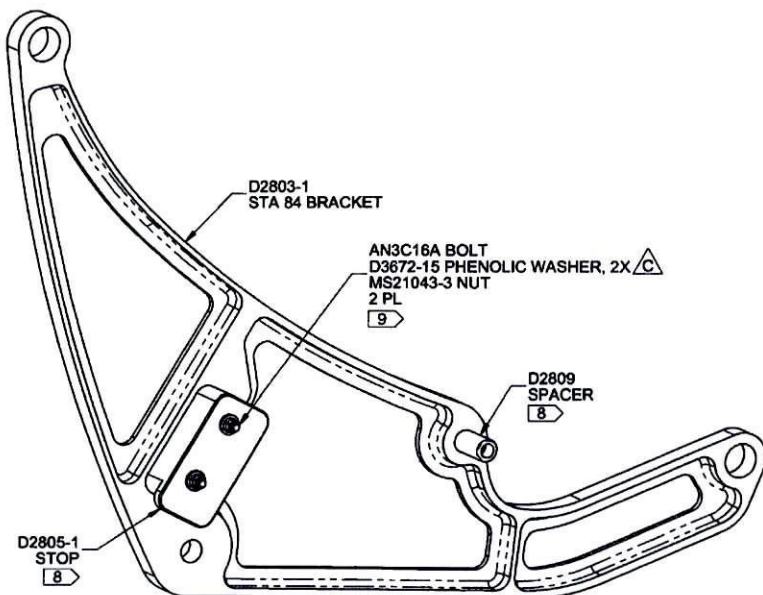
WITHOUT NOTICE

WORK ORDER

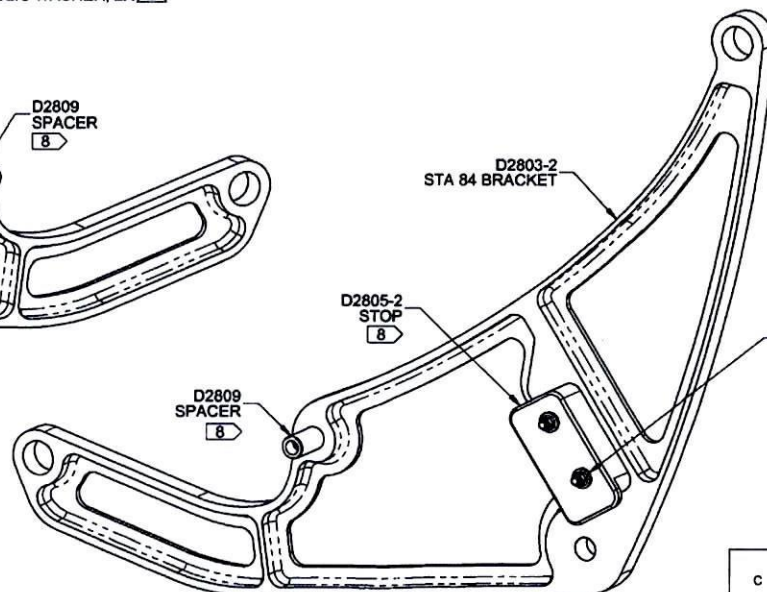
NO. 172088

FEB 13 2018

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2803-041	BRACKET ASSY
		X	D2803-042	BRACKET ASSY
1	1		D2803-1	STA 84 BRACKET
2		1	D2803-2	STA 84 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING



D2803-041 BRACKET ASSY



D2803-042 BRACKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.58 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

RELEASED

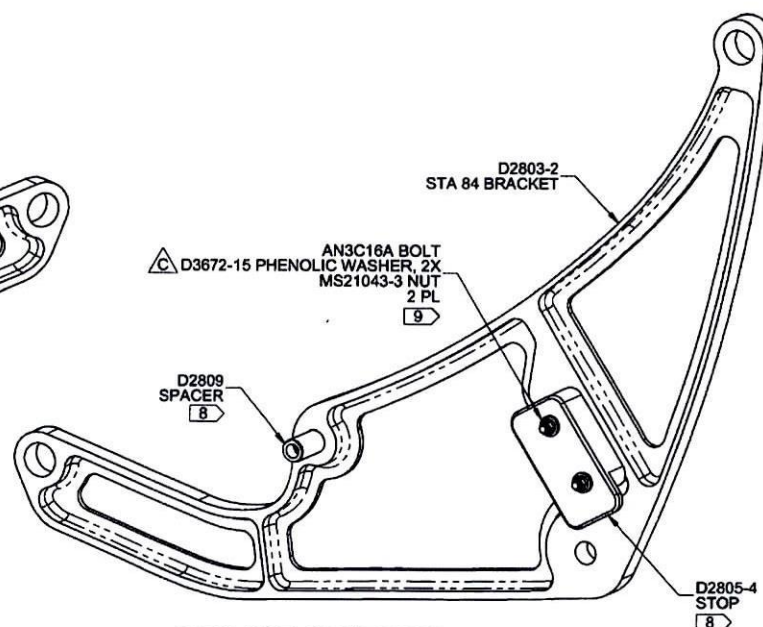
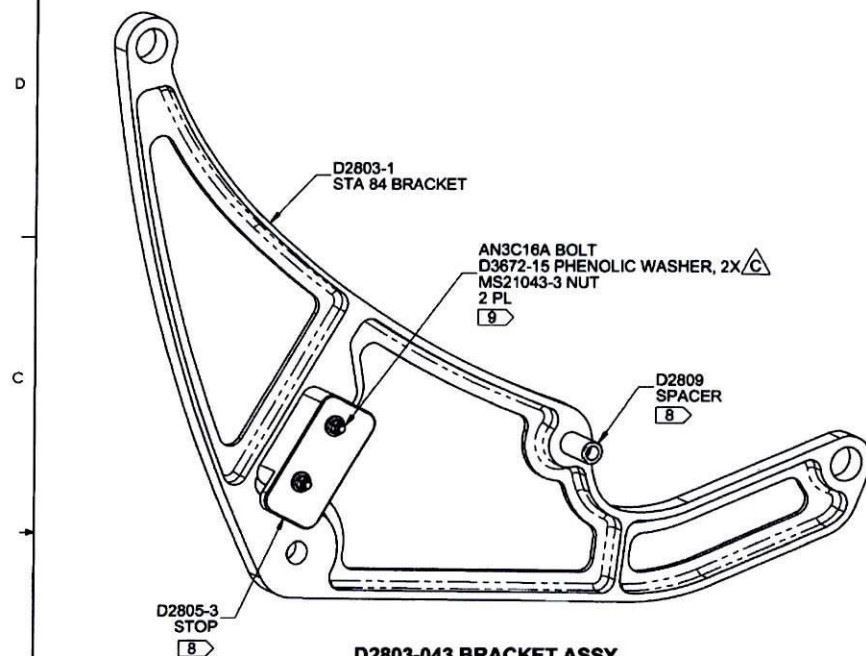
2016 JUN 22 q
ECN 16-661

C	REVISE TO CURRENT FORMAT; ADD DETAILS A AND F AND SECTION E-E; D3672-15 WAS NAS 1515H3. ZONES C3-302-4 AND B3-302-3: 2.656 WAS 2.654 AND 0.436 WAS 0.437; REASON: CAD ERROR.	MB	16.04.11
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D2803	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 84 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1

ITEM	QTY -043	QTY -044	P/N	DESCRIPTION
	X		D2803-043	BRACKET ASSY
		X	D2803-044	BRACKET ASSY
1	1		D2803-1	STA 84 BRACKET
2		1	D2803-2	STA 84 BRACKET
3	1		D2805-3	STOP
4		1	D2805-4	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING



RELEASED

2016 JUN 22 up

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APPROVED

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REV. C

SHEET 2 OF 4

SCALE

NTS

8 7 6 5 4 3 2 1

